

Work Order ID 70241

Wednesday, June 01, 2011 2:47:49 PM



Page 1

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 6/1/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/06/01 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4034

B

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

11.06.14 (3)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.06.14
11.06.14

3 φ

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

11.06.14

(K3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 70241

Page 2

Wednesday, June 01, 2011 2:47:49 PM

Item ID: D4034-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Fwd Upper Rib Assembly
Start Date: 6/1/2011 Start Qty: 3.00  Cust Item ID:
Required Date: 6/7/2011 Req'd Qty: 3.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		300	11-06-14	(3)			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/6/14 MF 11-06-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 01, 2011 2:47:47 PM

Page 1

Work Order ID: 70241

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly



Start Date: 6/1/2011

Required Date: 6/7/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 Rib		Manufactured	No			100	Each	13.0000	1	3			
<div> <div>Location</div> <div>WA006</div> <div>67271</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>13</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4034-5 Rib		Manufactured	No			100	Each	6.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>69015</div> <div>69636</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2327-3 Spacer Bushing		Manufactured	No			100	Each	9.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>69436</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

SAD 11-06-03

3

SAD 11-06-03

3

SAD 11-06-03

3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, June 01, 2011 2:47:47 PM

Work Order ID: 70241



Parent Item: D4034-043



Parent Item Name: Fwd Upper Rib Assembly

Start Date: 6/1/2011

Required Date: 6/7/2011

Start Qty: 3.00

Required Qty: 3.00

D4021-7

Manufactured No

100

Each

11.0000

1

3



SAN

11-06-03

Hoop

Location

Loc Qty

Loc Code

WA

11

56996

0

67268

1

69637

10

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

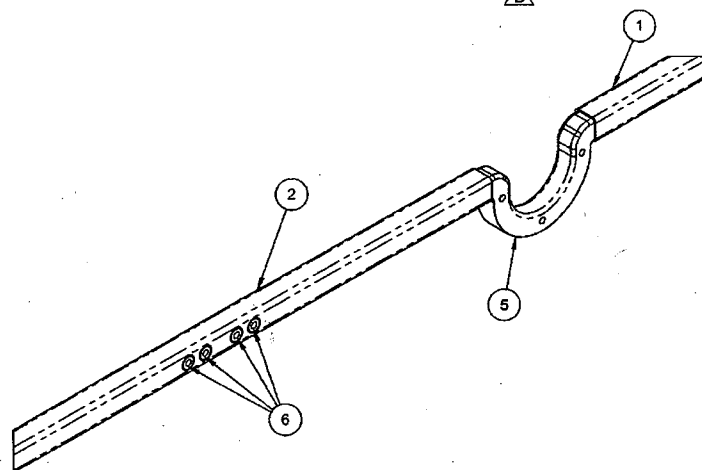
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

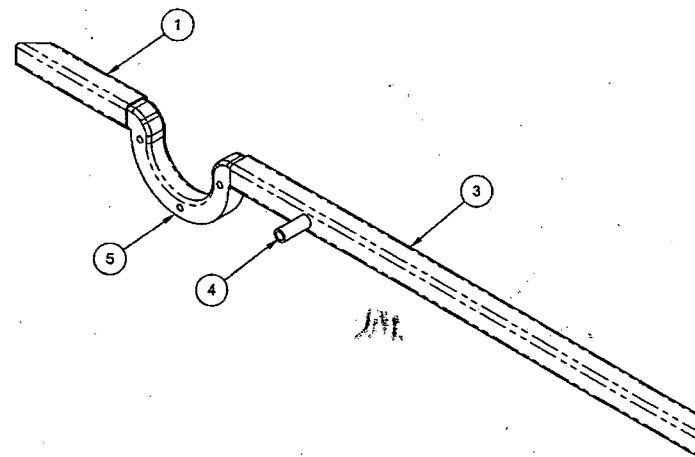
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

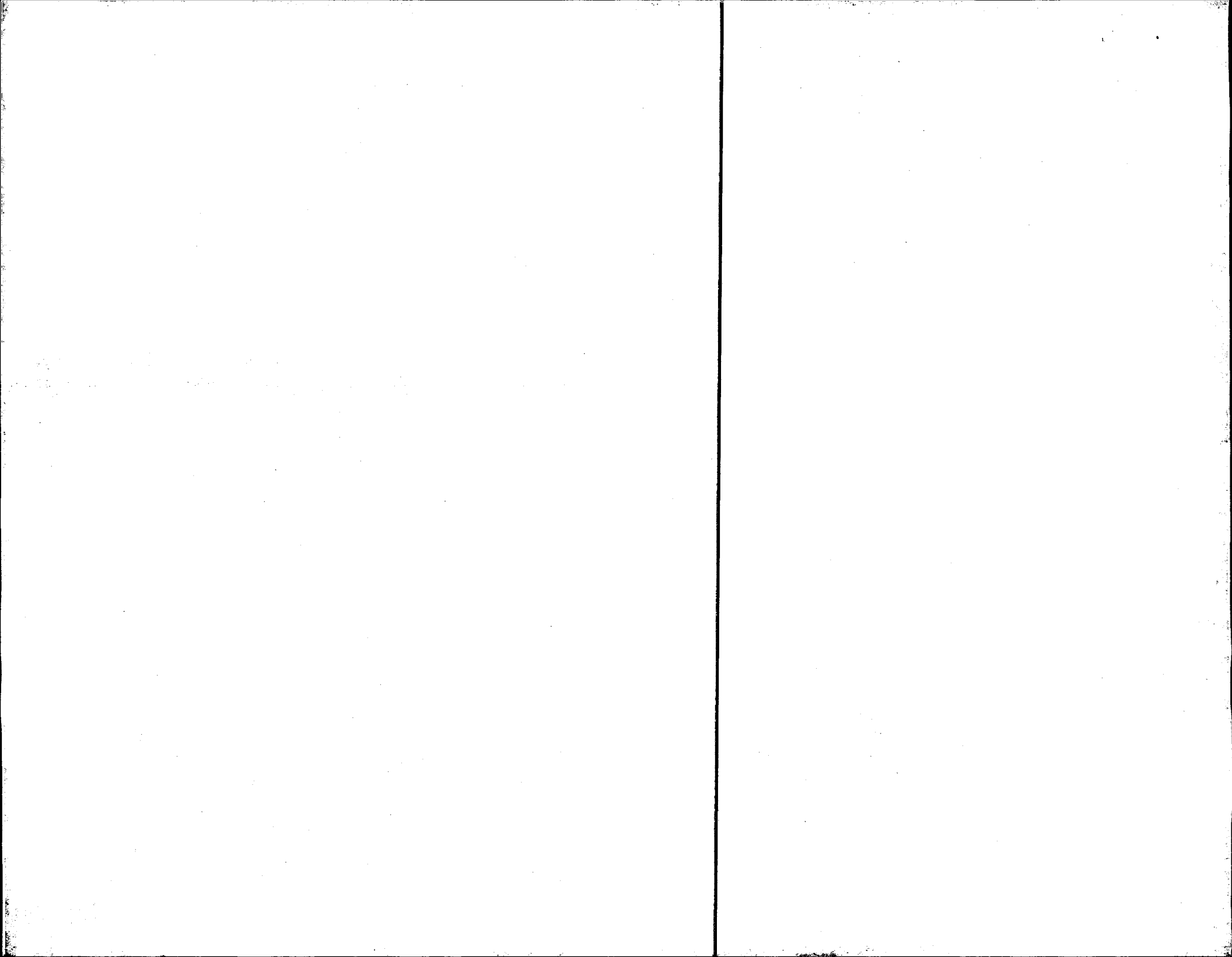


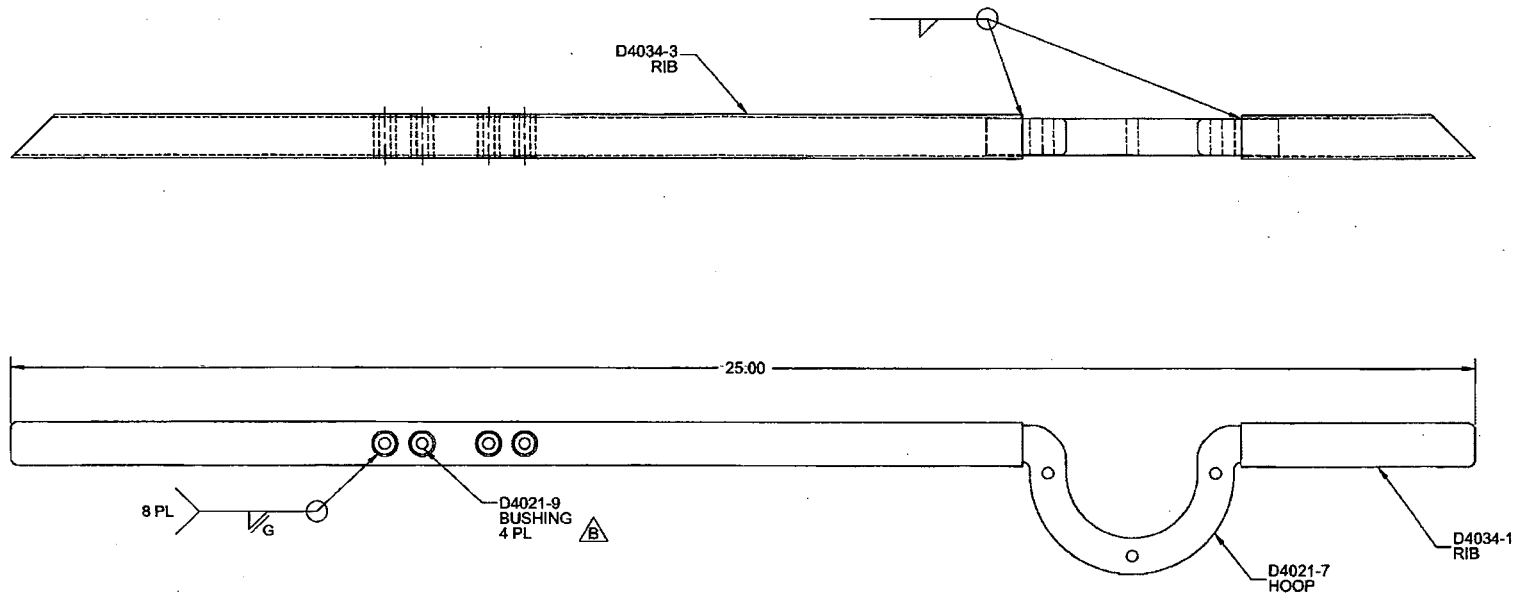
D4034-043 FWD UPPER RIB ASSY

CL11/06/01
W10,70241

RELEASED
R 2011-01-18
MB

REV.	DESCRIPTION	BY	DATE
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	MB	D4034	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





D4034-041 AFT UPPER RIB ASSY

RELEASED
2011-01-30

NOTES:

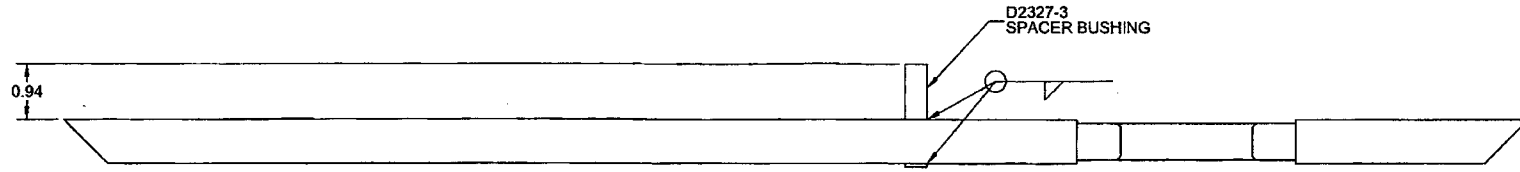
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	AS	D4034	SHEET 2 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	UPPER RIB ASSY, BASKET BASE	NTS
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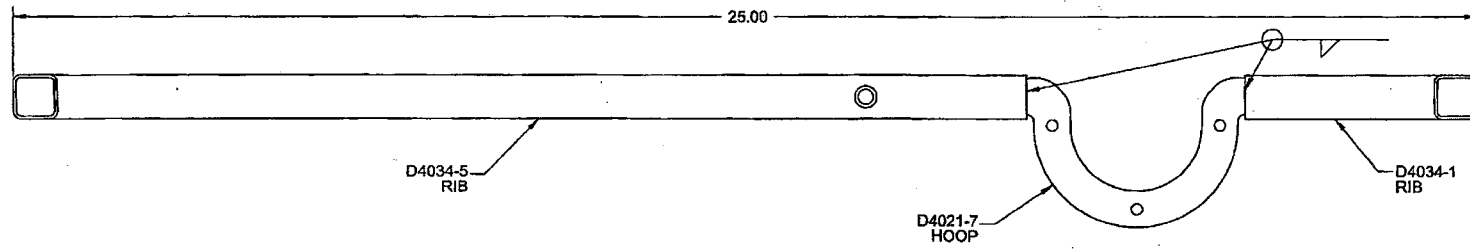
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C

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B

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D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18
JW

NOTES:

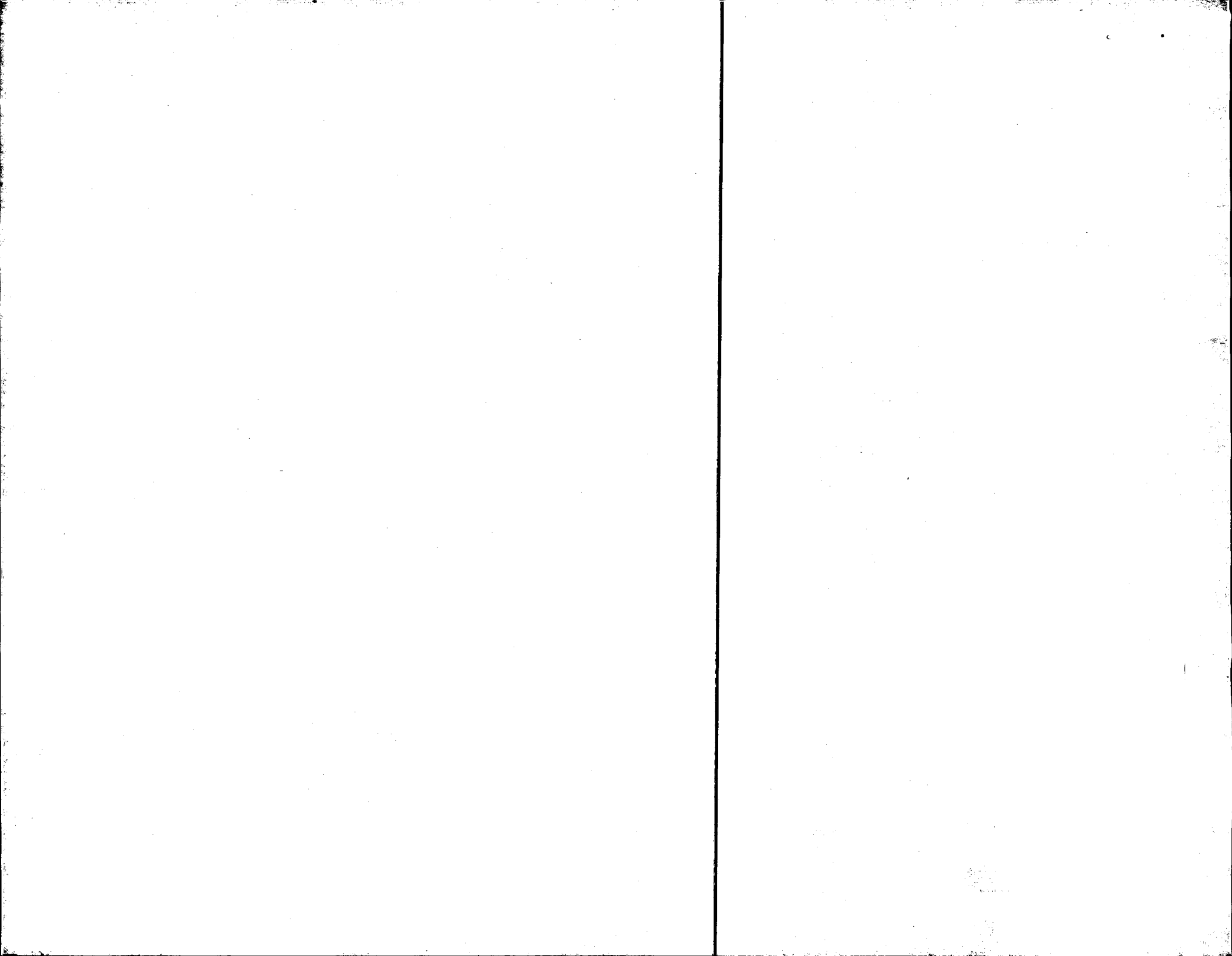
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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A

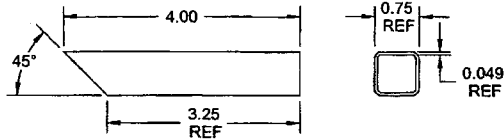
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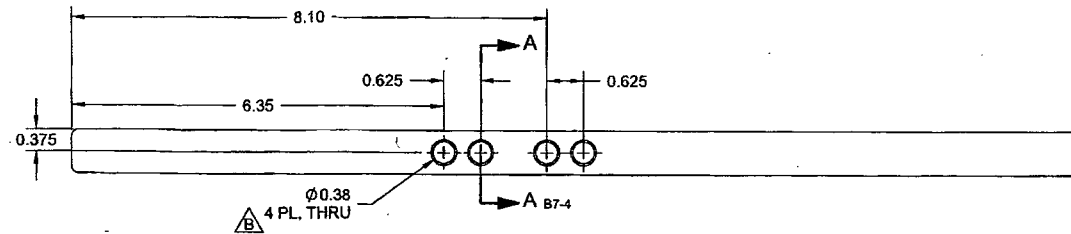
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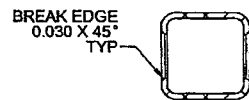
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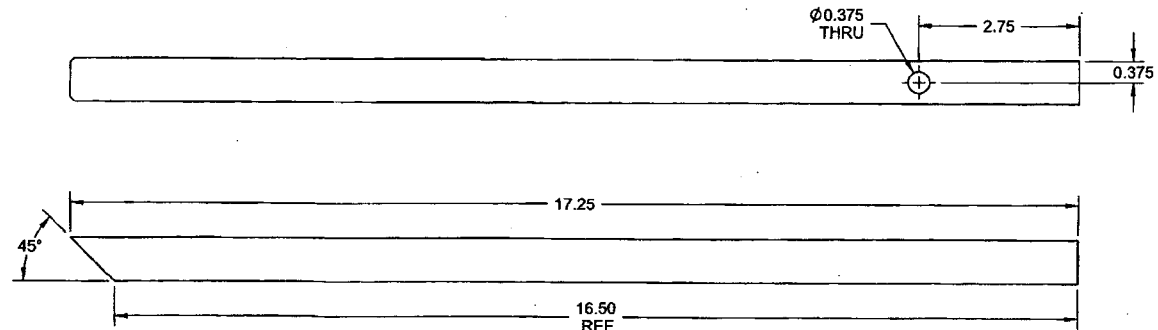
D4034-1 RIB



D4034-3 RIB



SECTION A-A D4-4



D4034-5 RIB

RELEASED
2011-01-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KS	DRAWING NO.	REV. B
MFG. APPR.	WJ	D4034	SHEET 4 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	UPPER RIB ASSY, BASKET BASE	NTS
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8 7 6 5 4 3 2 1

A

A